

Date: Friday, 5/25/2007 8:16:07 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32572
Estimate Number : 10258
P.O. Number :
This Issue : 5/25/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1 / Type : SMALL / MED FAB
Previous Run : 31694
Written By :
Checked & Approved By : 07.05.28
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 K J/RF

Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Part Number : D2332041
Drawing Number : D2332 REV C1
Project Number : N/A
Drawing Revision : C1
Material :
Due Date : 6/15/2007 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

M 104 862 (37)

M 103 987
M 104 593
M 104 489
M 104 640

Batch

M 104 52

2.0 M304R250 1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch M 104 128

(x37)

07-07-30

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

(x37)

(38) 07-07-30

4.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s)

304 RD Tube .500 x .035W

M 104 862 (37)
M 103 987 19
M 104 593 2
M 104 489 13
M 104 640 9

(x37)

8B 07/06/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	App QC Insp	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

ml 07/07/30 x37

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M104721

ml 07/07/30
07/07/31 (37)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 01-02-31 (37)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/07/31 x37

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

ml 07/08/01

x37

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) 37x

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M101291

✓ ml

Dart

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~60.0000~~ Each(s) **111X**

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M104214 X3
M104936 X108

✓
ml

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s) **37X**

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M102552

✓
ml 07/08/01

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2708 01

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2 Assy in GA
35 store

ml 07/08/01

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.02
JH

Job Completion



ml 07.08.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

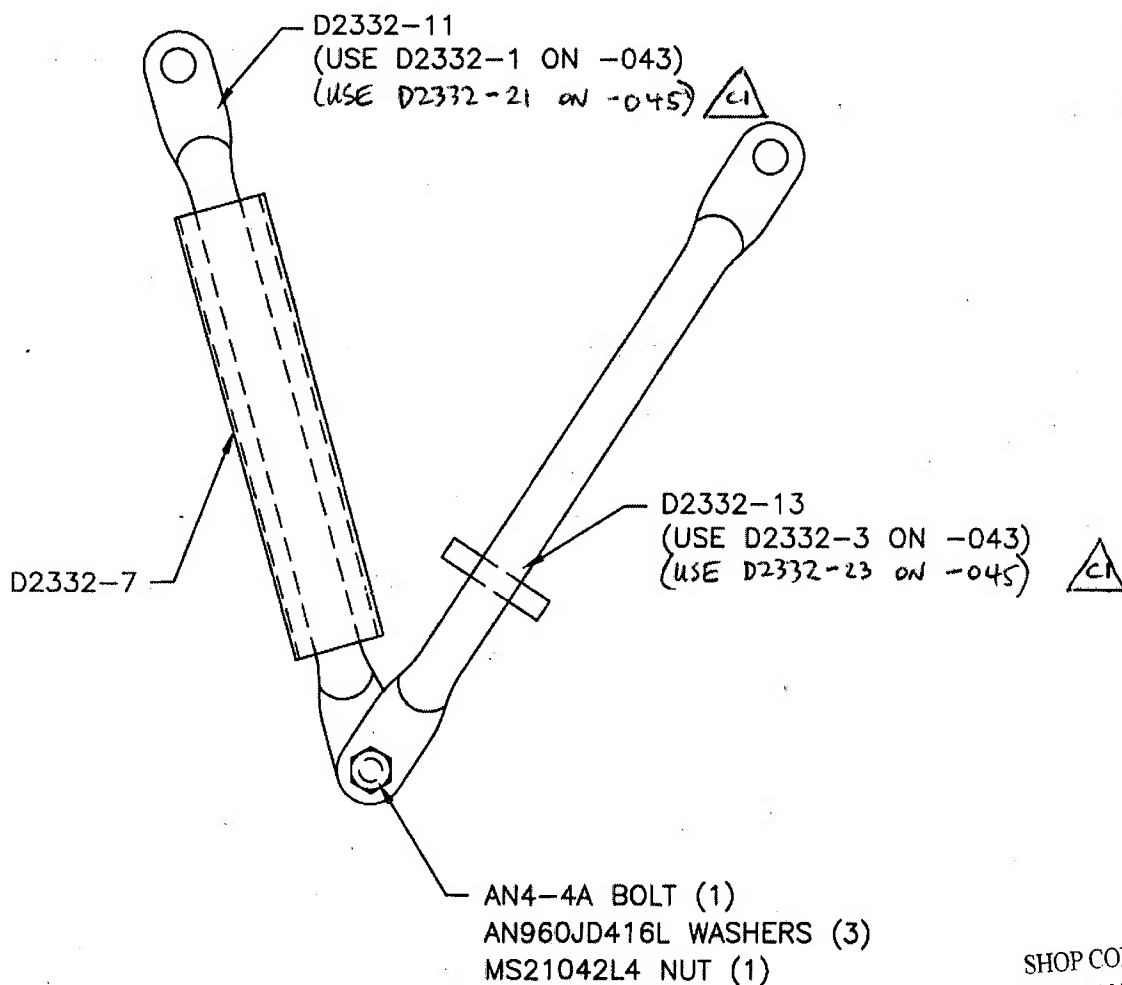
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	# 40 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR) \triangle C1

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WORK ORDER
NO. 32572

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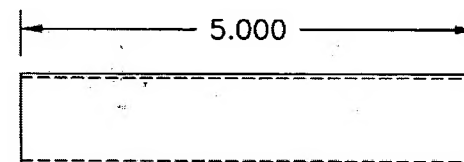
4431

W. J. L. J.

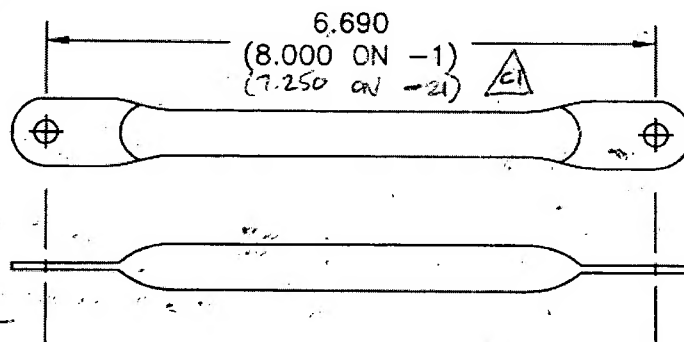
DART

QA CONTROLLED

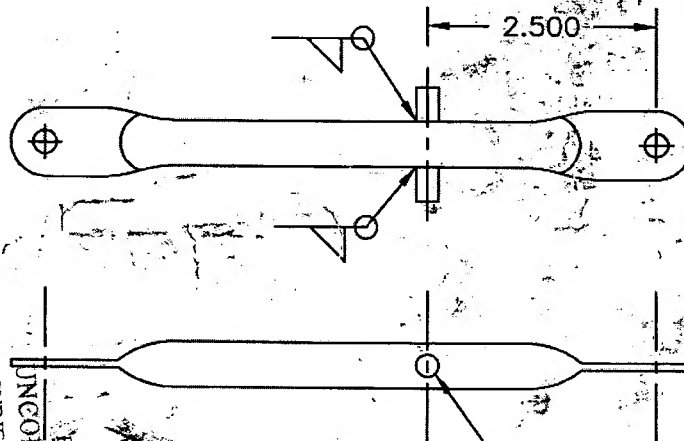
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MATE - 0.1" PROP 6.67" LONG (END)
C1	03.08.06	MATE - 0.43" PROP 8.00" LONG (INT)
		ADD - 0.45" PROP 7.25" LONG



D2332-7 LOCKING COLLAR



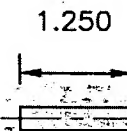
D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13

M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5
D2332-23 SIMILAR - M/F D2332-21 & D2332-5



D2332-5 STOP PIN

DRILL 1/4 HOLE FOR D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.01.04

WORK ORDER
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